

Date: Monday, 9/10/2007 1:27:45 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET		
Job Number	34484B	Part Number	: D2658		
Estimate Number	10339	Drawing Number	: D2658 REV D		
P.O. Number	N/A	Project Number	: N/A		
This Issue	9/10/2007	Drawing Revision	: D		
Prsht Rev.	NC	Material	: N/A		
First Issue	N/A	Due Date	: 9/30/2007 Qty: 20 Um: Each		
Previous Run	34076B				
Written By					
Checked & Approved By					
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S12GA	1010/1025/A21/6aA SHEET	
		Comment: Qty.: 0.1197 sf(s)/Unit Total : 2.3940 sf(s) 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK Batch: <u>M1010S12GA</u> 101094 FB 07-09-14	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2858 Dwg Rev: <u>D</u> 07-09-14 Prog Rev: <u>D</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Deburr as required.	
		2-Bend on CNC brake using DT8254 Identify as D2658	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

Job Number: 34484B

Part Number: D2658

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Eu 07/09/17 (x26)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/17 (20)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

Job Completion



07/09/18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34484B
Description: Lug Bracket	Part Number:	D2658
Inspection Dwg: D2658	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article □ Prototype

Measured by: <u>BB</u>	Audited by: <u>CR</u>	Prototype Approval:	N/A
Date: <u>07-09-14</u>	Date: <u>21/09/14</u>	Date:	N/A

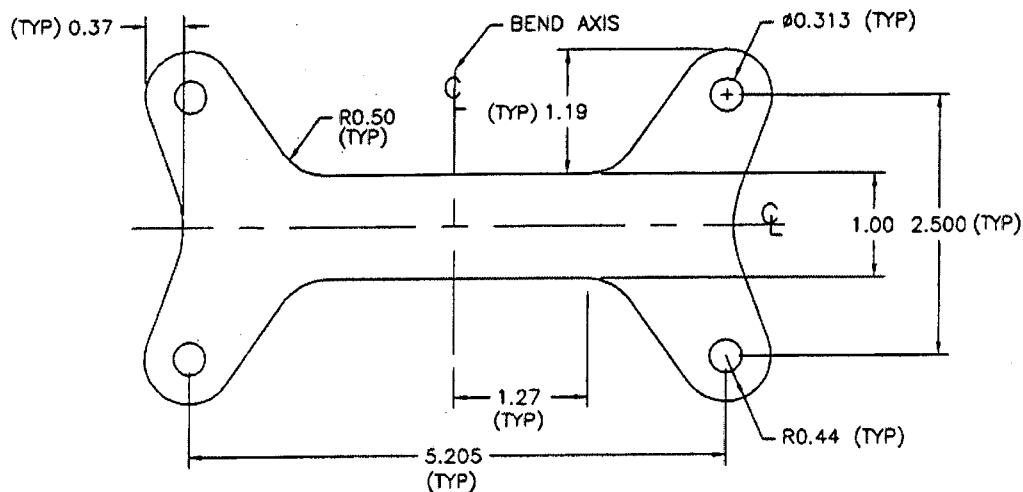
Rev	Date	Change	Revised by	Approved
A	06.11.13	New Issue	KJ/JLM	<i>[Signature]</i>



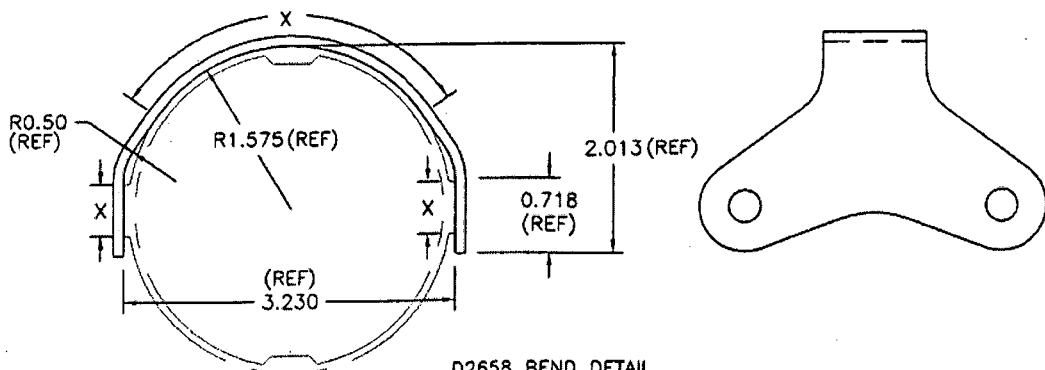
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
	KE	D2658	SHEET 1 OF 1
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34484 F

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES